

Work Order ID 137690

Wednesday, October 07, 2015 12:43:20 PM

D 4839-1
B 137690
REV. A

137690

Page 1

Item ID: D4839-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Blade

Start Date: 10/07/15 Start Qty: 21.00

21

Cust Item ID:

Required Date: 10/07/15 Req'd Qty: 21.00

21

Customer:

Reference:

Approvals:

Process Plan

Date: 15-10-7

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4839

REV A

100

0.00

100

Packaging

Memo

0.00

Packaging

PULL FROM STOCK:

646.9711 B

129676 X11

RE-IDENTIFY AS D4839-1

130845 X10

21 15-10-07

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.01

Quality Control

N/A 15-10-07

120

Identify as per dwg & Stock Location: CCK/28

0.00

120

Packaging

Memo

0.00

Packaging

OCT 08 2015

DAS
03
9-03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 137690***137690***

Page 2

Wednesday, October 07, 2015 12:43:20 PM

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Revision ID: Stop ***NS2***
Item Name: Blade
Start Date: 10/07/15 Start Qty: 21.00 ***21*** Cust Item ID:
Required Date: 10/07/15 Req'd Qty: 21.00 ***21*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130 QC	Memo	0.03							
Quality Control									

ML5 OCT 09 2015

SH 20151008

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

Wednesday, October 07, 2015 2:49:20 PM

Page 1

Work Order ID: 137690

137690

Parent Item: D4839-1

D4839-1

Parent Item Name: Blade

Start Date: 10/07/15

Required Date: 10/07/15

Start Qty: 21.00

Required Qty: 21.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

646.9711

Manufactured No

Each

85.0000

21

646 9711

**

~~21~~ 10-10-07

Blade

Location

Loc Qty

Loc Code

CCK013

85

128367

25

129676

50

130845

10

11

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
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				OTHER :							

8 7 6 5 4 3 2 1

D

C

B

D

C

B

[17.5mm]
0.69in REF

[7.48mm]
0.294in X 30° CMF
BOTH SIDES

[4.50mm]
Ø0.177in TYP

[114.3mm]
4.50in

D4839-1 BLADE

[81.3mm]
3.20in
REF

[60.98mm]
2.400in

[30.48mm]
1.200in

[15.24mm]
0.600in

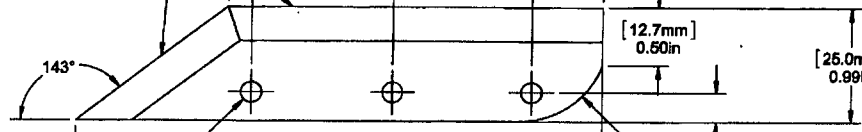
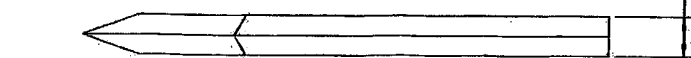
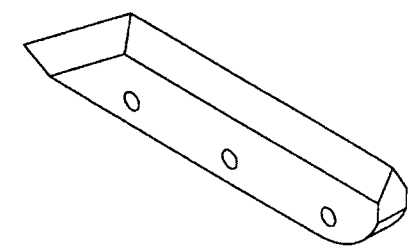
[12.7mm]
0.50in

[25.0mm]
0.99in

[6.35mm]
0.250in

[19.1mm]
R0.75in

[8.64mm, 0.00]
+0.000
-0.005
0.340in



143°

NOTES:

- 1) MATERIAL: AISI A2 TOOL STEEL PER ASTM A681 (DART SPEC MSTEEL-A2-80.375X4.500)
- 2) FINISH: PRIME IAW MIL-P-23377J TYPE1, CLASS N: 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs (0.13 kgs)
- 8) DO NOT BREAK EDGE OF BLADE, INTENDED TO BE SHARP
- 9) REFERENCE APICAL PART NUMBER 646.9711

Handwritten: 15-10-07
137690

RELEASED
2013-07-12
Handwritten signature

A NEW RELEASE		DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	<i>Handwritten: A.P.</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>Handwritten: al</i>	D4839	SHEET 1 OF 1
APPROVED	<i>Handwritten: [Signature]</i>	TITLE	SCALE
DE APPR.	<i>Handwritten: [Signature]</i>	BLADE	NTS
DATE	13.05.23	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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